

Work Order ID 55059

January 5, 2010 2:37:04 PM



Page 1

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

RF

Date: 10-1-05 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr
2-Drill #30 pilot holes using DT8678.
3- open holes to 5/16"

IX *MB* 10-01-06

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A".

IX *MB* 10-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end using DT8185

3-Deburr ends

4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

5-Locate DT 8973 & Drill Ground wire hole on top of Tube.

6-Install 3/16 cleco in Ground wire hole ,then drill all X-Boltholes using 3/16" drill.

7-Drill pilot holes for wearplates using DT8974

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

9- open ground wear holes to 0.391" as per section B-B

10-Open Aft Cap holes using .209" drill.

11-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

0.00

MB
10-01-06

DP

10-1-7

DP

10-1-8

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140

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Weld fwd cap D2964 per dwg D3582 and QSI 004
A/R AL ROD Batch: 1112860
2-Grind flush*ALUM 10-01-11*

150

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

27 Solobulu

160

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*27 Solobulu**(70)*

W/O:		WORK ORDER CHANGES					
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Run Start



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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

180 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M112395Exp Date: 5/2/12

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B

A/R AL ROD Batch: M112860

6-Grind welds flush

M 10/1/12

-A4M 10-1-14

200

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S7 81061/14



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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



⇒ S1010114

QC

Memo

0.00

Quality Control

215

Pressure Wash per QSI005 4.3

0.00



⇒ 10-00-18

HandFinish

Memo

0.00

Hand Finishing

ⓧ ⓧ

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



⇒ 10-01-16

Powdercoat

Memo

0.00

Powder Coating

M113 #70
START TIME 10:15pm
OVEN TEMPERATURE 320°F
FINISH TIME: 10:45AM

ⓧ ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC3- Inspect Part Finish

0.00



BR

10-01-21

⊗

⊗

QC

Memo

0.00

Quality Control

240

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Install Wearplate & Ground Wire inserts as per Dwg D3582.

BR 10-01-21.

P70
Last page

250

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: 1112345

Exp Date: 10/08

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and wa

11/10/12

O'RING LUBE 101223

Wing Walk as per drawing Batch: 112900

BR 10-01-21. ⊗

M-L 10/02/16 ⊗

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D117-762-041 PAR #: 7 ^{See NCR 10-011} Fault Category: Prod. Skid tubes NCR: Yes (No) DQA: / Date: 10-02-04
 Resolution: re-work Disposition: re-work QA: N/C Closed: / Date: /

NCR: 55059		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-02-04	250	Upon assembly of the D3508-9 wear plate, it was noticed that the holes in the tube were too narrow and causing the wear plate to lift in the center when tightened.	<i>[Signature]</i> QS/042	Drill jig feed hole angle slightly changed (came in) with use, due to mild O.D crushing on the tube from bending. DT8974 is Reworked.	See NCR 10-011	<i>[Signature]</i> 10-02-04	<i>[Signature]</i> QS/042	<i>[Signature]</i> 10-02-04
		R.C. Tooling.	<i>[Signature]</i> 10-02-04 QS/042	On the 2 most feed holes on the D3508-9 wear plate, slot the holes, square, to max 0.060" (or as necessary), to allow the bolts to tighten	<i>[Signature]</i> 10-2-11	<i>[Signature]</i> 10-02-04	<i>[Signature]</i> 10-02-04 QS/042	<i>[Signature]</i> 10-02-04
			<i>[Signature]</i> 10-02-04 QS/042	without any bending up of the wear plate. * open/slot, square to 0.060" maximum towards center line. - NON STRUCTURAL, ACCEPTABLE	<i>[Signature]</i> 10-2-11	<i>[Signature]</i> 10-02-04	<i>[Signature]</i> 10-02-04 QS/042	<i>[Signature]</i> 10-02-04

NOTE: Date & initial all entries

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Customer:

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Picklist Print

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Page 1

12

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Alt Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	-----------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2962-150

Manufactured

No

110

Each

36.0000

1.0000



3.540 Outer Tube, Extrut

MB 10-01-06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

28672

36

D2964

Manufactured

No

140

Each

29.0000

1.0000



Cap

TD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

14101

29

D2971

Manufactured

No

190

Each

36.0000

1.0000



Cross Bolt Spacer

1 BE 10/01/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

44445

36

1 BE 10/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3584-1		Manufactured	No			190	Each	1.0000	1.0000			

Web

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG

1

B552DS

1 M 10/11/12

54349

1

D2973

Manufactured

No

190

Each

197.0000 2.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

197

14636

197

2

DE 10/21/14

D3662-3

Manufactured

No

190

Each

33.0000 1.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

33

44456

33

1

DE 10/21/14

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Shop Packet Print

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D3662-1 		Manufactured	No			190	Each	21.0000	3.0000			
Crossbolt Spacer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	21	
39022	3	
39585	18	

ALS4-1032-130 	Purchased	No				240	Each	2,717.000	36.0000			
Insert												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2717	
110511 ✓	2717	

ALS4-428-165 	Purchased	No				240	Each	38.0000	2.0000			
Inserts												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	38	
6989 ✓	38	

3 85 10/01/14

36 BK 10-01-26.

2 BK 10-01-26.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2965  Cap, 105 Skidtube		Manufactured	No			250	Each	54.0000	1.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP4

54

52057 ✓

54

1 BL 10-01-21

D3508-3

Manufactured No

250

Each

6.0000

1.0000



Wearplate

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP21

6

51386 ✓

6

1 BL 10-01-21

D3508-9

Manufactured No

250

Each

2.0000

1.0000



Wearplate

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

54580

2

46596

2

1 BL 10-01-21

January 5, 2010 2:37:08 PM

Shop Packet Print

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3558-3  Gasket		Manufactured	No			250	Each	11.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse


ST

11

51391 ✓

11

1 BR 10-01-21

D3558-9  Gasket		Manufactured	No			250	Each	15.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse


ST

15

50928 ✓

15

1 BR 10-01-21

D3558-11  Gasket		Manufactured	No			250	Each	13.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

40399 ✓

1

42254 ✓

12

1 BR 10-01-21

January 5, 2010 2:37:09 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:37:09 PM

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Priority Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	----------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3558-13

Manufactured

No

250

Each

9.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

40400 ✓

4

42255

5

1 BL 10-01-21

D3508-11

Manufactured

No

250

Each

7.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

40398

2

46880 ✓

5

1 BL 10-01-21

D3508-13

Manufactured

No

250

Each

5.0000

1.0000



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

42252 ✓

5

1 BL 10-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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January 5, 2010 2:37:09 PM

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-051 Plug Assembly		Manufactured	No			250	Each	20.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

20

44633 ✓

20

D3492-049

Manufactured

No

250

Each

16.0000

2.0000



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

16

40356

1

44632 ✓

15

2/10-01-21

2/10-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:37:09 PM

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-053		Manufactured	No			250	Each	68.0000	6.0000			

Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

66

54641 ✓

66

Main Warehouse

ST

2

44063

2

AN960JD10L

Purchased

No

250

Each

4,867.000 2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4867

101291

16

104885

16

105793

197

109632

174

110985 ✓

4464

6 BR 10-01-21

2 BR 10-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:37:09 PM

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			250	Each	1,195.000	28.0000			
BOLT												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1195	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	586	
113359	14	
113422 ✓	500	

AN3C5A 	Purchased	No				250	Each	609.0000	2.0000			
Bolt												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST 113644	609	
111424	8	
111707	69	
112314	1	
113121	231	
113149	300	

28 BL 10-01-21

2 BL 10-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:37:09 PM

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining To Pick	Qty Issued	Date Issued	Status
AN960JD416L 		Purchased	No			250	Each	795.0000	2.0000			

Washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	795	
105078	4	
107008	54	
108583	40	
110153 ✓	297	
112492	400	

2 Bl 10-01-21

AN960C10L

Purchased

No

250

Each

416.0000

28.0000



washer

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
OFFSHORE		
NAS1149C0332R NG	100	
103585	100	
Main Warehouse		
ST	316	
112116	156	
112612	160	

28. Bl 10-01-21.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:37:09 PM

Work Order ID: 55059

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-4A		Purchased	No			250	Each	119.0000	2.0000			
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Bolt

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	119	
101291	3	
106918	1	
108138 ✓	58	
111295	57	

2 BL 10-01-21

NAS1611-012		Purchased	No			250	Each	60.0000	6.0000			
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O-RING

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	60	
108673 ✓	60	

6 BL 10-01-21

NAS1611-015		Purchased	No			250	Each	20.0000	2.0000			
-------------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



O-RING

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	20	
107178 ✓	20	

2 BL 10-01-21

January 5, 2010 2:37:09 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 2:37:09 PM

Work Order ID: 55059



Parent Item: D117-762-041



Parent Item Name: Replacement Skidtube

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: IPP RevD: add pressure wash DD 09.12.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-016		Purchased	No			250	Each	117.0000	2.0000			

O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	117	
107178 ✓	17	
112492	50	
113524	50	

2 BK 10-01-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

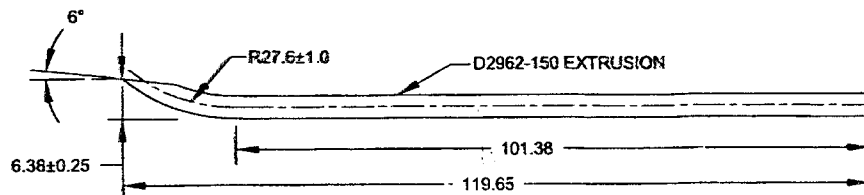
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

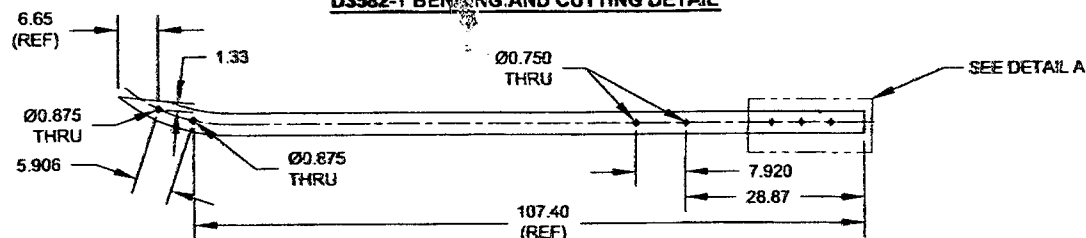
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3506-3	WEARPLATE
1	D3506-9	WEARPLATE
1	D3506-11	WEARPLATE
1	D3506-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

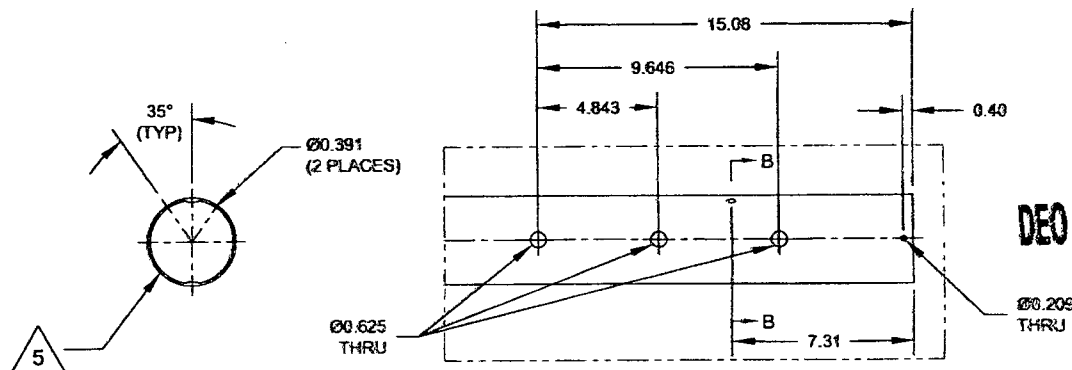
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

DETAIL A
SCALE 1:5

DEO ATTACHED

RELEASED
07-11-2007

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55059

RE 10-1-05

A		NEW ISSUE		PH	07.06.08
REV.		DESCRIPTION		BY	DATE
DESIGN	SA	DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWN	SA				
CHECKED	SA	DRAWING NO.	D3582	REV. A	
MFG. APPR.	SA			SHEET 1 OF 2	
APPROVED	SA			SCALE	
DE APPR.	SA			1:20	
DATE	07.06.08				

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

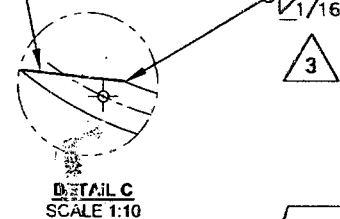
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

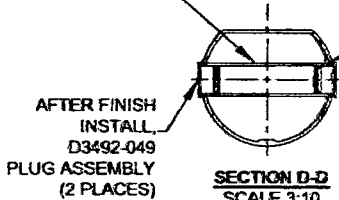
NOTE: Date & initial all entries

D2964 CAP
(GRIND FLUSH)



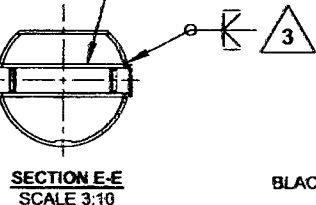
DETAIL C
SCALE 1:10

D2971 SPACER



SECTION D-D
SCALE 3:10

AFTER FINISH
INSTALL
D3492-049
PLUG ASSEMBLY
(2 PLACES)



SECTION E-E
SCALE 3:10

SECTION D-D NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

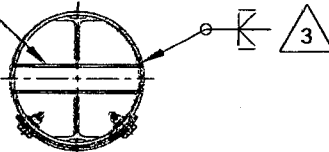
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2971 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-049 PLUG ASSEMBLY (2 PLACES)

SECTION E-E NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-051 PLUG ASSEMBLY (2 PLACES)

D2973 SPACER
(2 PLACES)



SECTION F-F
SCALE 3:10

SECTION F-F NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2973 SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.625 DRILL TO REMOVE SPILL OVER

D3584-1 WEB (REF)

D3662-1 SPACER
(3 PLACES)

AFTER FINISH, INSTALL
AELS-1032-130
INSERT (36 PLACES)

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(28 PLACES)

SECTION G-G
SCALE 3:10

AFTER FINISH, INSTALL
ALS7-428-165 INSERT (1)
AN4-4A BOLT (1)
AN960JD416L WASHER (1)
(2 PLACES)

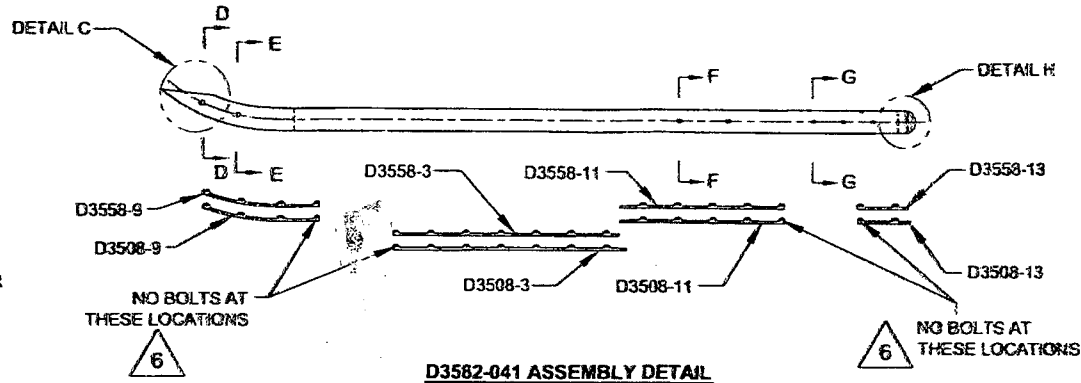
AFTER FINISH
INSTALL
D3492-053
PLUG ASSEMBLY
(6 PLACES)

SECTION G-G NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-053 PLUG ASSEMBLY (6 PLACES)

DETAIL C



D3582-041 ASSEMBLY DETAIL

NO BOLTS AT
THESE LOCATIONS

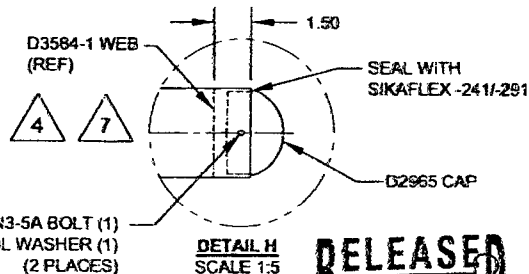
NO BOLTS AT
THESE LOCATIONS

BLACK ANTI-SKID

BLACK ANTI-SKID (TYP)

D3582-041 BLACK ANTI-SKID DETAIL

DEO ATTACHED



DETAIL H
SCALE 1:5

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	PH	PORT HADLOCK, WA
CHECKED	PH	DRAWING NO. REV. A
MFG. APPR.	PH	D3582 SHEET 2 OF 2
APPROVED	PH	TITLE SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY 1:20
DATE	07.06.08	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

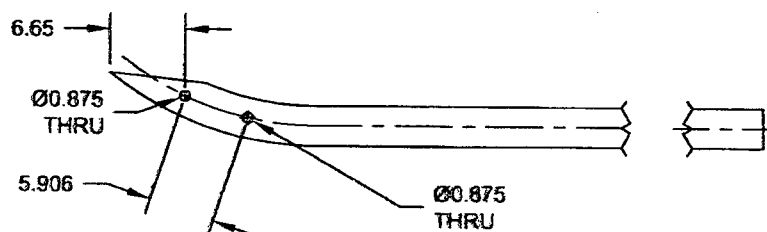
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

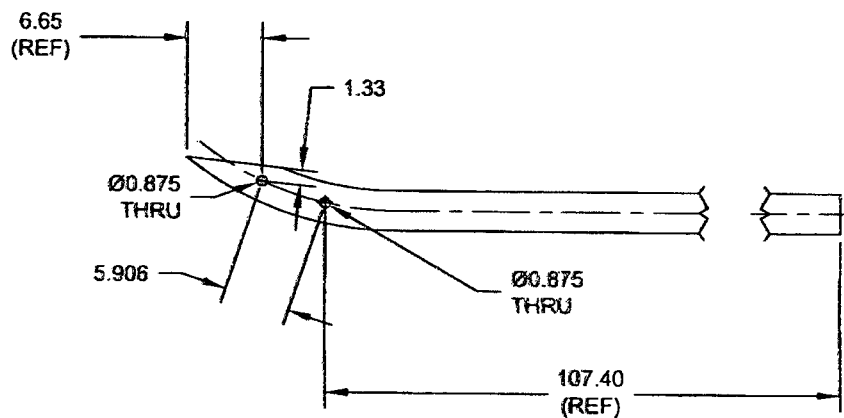
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE N.T.S.
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/24/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



w/o 55059

RELEASED
09/04/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54161
Part number: D17-762-041
Description: 17 sk.d tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Date of Test Coupon 09.12.10

Welder Barclay Elliott Date of Test Coupon 09/12/10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld